

Work Order ID 83448

83448

Page 1

Wednesday, April 18, 2012 8:41:57 AM

Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 4/18/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2739	Rev E
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100

0.00

100

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

- 1-Cut D2600-5 to length as per Dwg D2739.
- 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
- 3-Use uni-bit to open holes to finish size as per Dwg D2739.
- 4-Bevel Fwd end of extrusion and Deburr holes and ends.
- 5-Deburr

120

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

Handwritten signature and date: 12-04-27

Handwritten circled number 3 and date: 7/6/12-4:30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83448

83448

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Wednesday, April 18, 2012 8:41:57 AM

Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam
 Start Date: 4/18/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

DD 12-5-1

QC 12/20/30

12/5/1 J
ME 12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 18, 2012 8:42:01 AM

Page 1

Work Order ID: 83448

83448

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 4/18/2012

Required Date: 4/25/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev: C02.11.28ReformatKJ
 IPP Rev: D 06-03-21 As Per Rev C JLM
 IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F
 10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	152.0000	1	5			
D2600-5-108									**	(5)		11-04-27	
Extrusion 'I Beam' thin													

Location

Loc Qty

Loc Code

LG

152

47814

20

73909

132

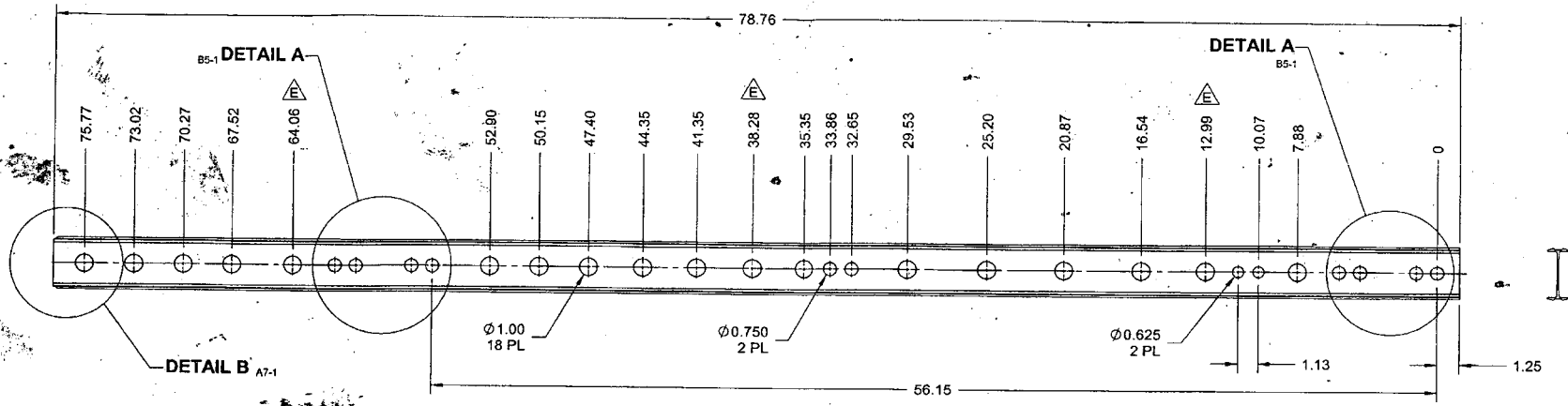
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

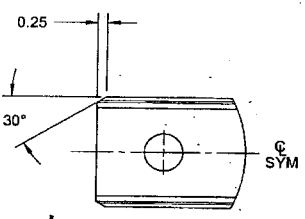
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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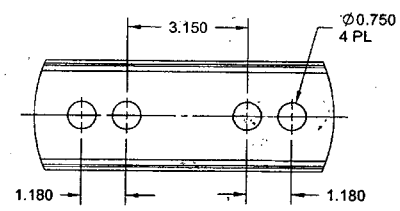
NOTE: Date & initial all entries



D2739 WEB



DETAIL B
SCALE 3X C7-1



DETAIL A
SCALE 3X D7-1, D2-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83448 MLJ
12/04/18

RELEASED
2010-11-01

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART-QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (DS-1), 64.06 WAS 64.77 (D7-1); ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2739 TITLE WEB REV. E SHEET 1 OF 1 SCALE NTS	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP	DATE 10.10.08	
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W/O:		WORK ORDER CHANGES						
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